

Slide 1: Aircraft Electrical Wiring Interconnect System (EWIS)

Best Practices

Job Aid

Revision: 2.0

[Speaker notes]

This job aid covers applicable 14 CFR part 25 aircraft (although it is also widely acceptable for use with other types of aircraft such as military, small airplanes, and rotorcraft). This job aid addresses policy; industry EWIS practices; primary factors associated with EWIS degradation; information on TC/STC data package requirements; EWIS selection and protection; routing, splicing and termination practices; and EWIS maintenance concepts (including how to perform a EWIS general visual inspection). The job aid also includes numerous actual aircraft EWIS photos and examples.

[End speaker notes]

Slide 2: Additional Notes

This slide does not pertain to this accessible version:

- This presentation contains additional speaker notes for most slides.
- It's advisable to read these notes while viewing the slide presentation

Slide 3: Printing the Additional Notes

This slide does not pertain to this accessible version:

To print the slides and accompanying speaker notes:

- Navigate back to the FAA Aircraft Certification job aids web page
- Open and print "Printable Slides and Notes."

Slide 4: Background

1. Why the need for EWIS best practices Job Aid?
 - a. Accident/Incident Service History
 - b. Aging Transport Systems Rulemaking Advisory Committee (ATSRAC)
 - c. Enhanced Airworthiness Program for Airplane System (EAPAS)
 - d. EAPAS Rule Making

[Speaker notes]

Historically, wiring and associated components were installed without much thought given to the aging aspects:

- Fit and forget.
- Unanticipated failure modes and their severity.

- Arc tracking.
- Arcing.
- Insulation flashover.

Maintenance programs often did not address these aging aspects. Service history also indicates that Foreign Object Damage (FOD) such as drill shavings, caustic liquids, etc. does cause EWIS degradation that can lead to EWIS faults.

[End speaker notes]

Slide 5: Introduction

Late 1980s, wiring safety concerns raised due to accidents & incidents
 Investigations found common degrading factors in airplane electrical wiring systems
 Investigation into wiring
 issues done by industry,
 civil aviation authorities,
 other government
 agencies

[Speaker notes]

The aging issues in wiring systems were made known by the following:

- In the late 1980s, wiring safety concerns were raised due to accidents & incidents
- Investigations found common degrading factors in airplane electrical wiring systems
- Investigation into wiring issues done by industry, civil aviation authorities, government agencies

[End speaker notes]

Slide 6: Wiring Investigation Findings

- Design
- Maintenance
- Operation
- Training
- Repair
- Installation

[Speaker notes]

As listed here, the investigation of the aircraft wiring revealed there are several factors, together with time, that play a role in wiring degradation.

[End speaker notes]

Slide 7: Aging Transport Systems Rulemaking Advisory Committee (ATSRAC)

Phase I

- Tasked to develop and propose recommendations for airworthiness enhancements to the FAA.
- Tasks completed and reports approved by ATSRAC in January 2001.

Phase II

- Tasked to develop and propose airworthiness enhancements based on the recommendations developed in Phase I.
- Tasks completed and reports approved by ATSRAC in January 2003.

Phase III

- Tasked to assist FAA with the implementation of the enhancements developed in Phase II.

[Speaker notes]

Aging Transport Systems Rulemaking Advisory Committee

Phase I – The following tasks were undertaken by ATSRAC in this phase for developing and proposing recommendations for airworthiness enhancements to the FAA:

Sampling inspection of the fleet

Review of fleet service history

Improvement of maintenance criteria

Review and update standard practice for wiring

Review air carrier and repair station inspection and repair training programs

Phase II – The following tasks were undertaken by ATSRAC in this phase to develop and propose airworthiness enhancements based on the recommendations developed in Phase I:

Improving wire system certification requirements

Enhancing wiring maintenance procedures and instructions

Enhancing and augment current training programs

Standardizing the format of Standard Wiring Practices Manual

Study of aging issues in small transport airplanes electrical wiring

Phase III - The following tasks are currently undertaken by ATSRAC in this phase to assist FAA with the implementation of the enhancements developed in Phase II:

Provide assistance in implementation of the airworthiness enhancements and, if requested, develop alternatives to rulemaking for implementation of training and maintenance enhancements.

Assist in review and implementation of new technologies developed for mitigating the aging issues in aircraft wiring systems.

Study and develop enhancements for wiring maintenance procedures for small transport airplanes (with a passenger capacity between 6 to 30 and less than 7,500 pound payload).

[End speaker notes]

Slide 8: Routing/Chafing In-Service Examples

[Graphic]

Wires chafing against metal frame and chaffng against each other

[End graphic]

[Speaker notes]

These photos show examples of findings. These examples show the potential for chafing and arcing.

[End speaker notes]

Slide 9: Accumulation of Dirt and Lint

[Graphic]

Wires covered in dirt and lint

[End graphic]

[Speaker notes]

Accumulation of dirt and lint create a potential for smoke and fire, making inspection of the EWIS impossible.

[End speaker notes]

Slide 10: Coil and Stow In-Service Example / Result

[Graphic]

Cut wires with ends exposed and cut antenna that is exposed

[End graphic]

[Speaker notes]

This slide shows an example of improper termination of unused wires. On the left side, there are no termination caps and it's improperly stowed.

On the right side is a photo of an improper maintenance action. Coaxial cable was left attached to an antenna instead of being removed in its entirety – at least it should have been detached from the antenna. Consequently, lightning attached to the antenna, traveled along the EWIS, and caused a fire in the cabin.

[End speaker notes]

Slide 11: Bend Radius Problem In-Service Example

[Graphic]

Wires bent 180 degrees and bundled together

[End graphic]

[Speaker notes]

This photo shows an improper bend radius installation of electrical wire. The proper bend radius for wire on aircraft should be 10 times the outside diameter of the largest diameter wire in the bundle for one side supported (3 times for two sides supported.) Standard industrial practice and is in AC 43.13-1b and Standard Wiring Practices Manual (SWPM).
[End speaker notes]

Slide 12: Arcing Event

[Graphic]

Arcing results with terminals and wires

[End graphic]

[Speaker notes]

These photos illustrate an improper maintenance action caused when the airplane's airworthiness certificate was relocated. The attach screw penetrated the power cables. The FAA maintenance inspector riding on the jump seat caught his clothing on fire.

The arcing event, which originated from inside the electrical power center, burned a hole through the left side of the hallway (looking forward) between the cockpit and cabin.

[End speaker notes]

Slide 13: Effect of Improper Maintenance

[Graphic]

Top shows chafing wires caused conduit burn-through on generated power feeder in conduit. The bottom shows that heat from arcing caused holes in fuel line.

[End graphic]

[Speaker notes]

The left side of this photo shows failure of wire due to chafing inside a metallic conduit.

Created an arc, which created holes in the fuel line below the conduit. Caused by improperly replacing an existing power feeder.

[End speaker notes]

Slide 14: Effect of Poor Design

[Graphic]

Burn holes on side of airplane and in the floor under a passenger seat

[End graphic]

[Speaker notes]

This shows arcing due to lavatory servicing lines leaking on damaged EWIS, creating an arc that caused a fire that led to extensive damage inside and outside of the airplane. Business class lavatory drip shield not installed – water shorted cannon plug in wire bundle below deck.

Maintenance, design, training, operations – all need improvement.

[End speaker notes]

Slide 15: Previous Regulations Inadequate

- Previous regulations fell short of providing specific wiring-related requirements.
- Specific wiring-related requirements needed to be included in certification and operational regulations.

Slide 16: Culture Shift: EAPAS Safety Initiative

- Recognizing importance of EWIS in safe operation of airplanes leads to being more proactive; FAA is
 - Treating wiring as a system
 - Mandating DAH support of the initiative
 - Integrating FAA lines of business; joint AFS/AIR activity; and cooperation with & between DAHs and operators

[Speaker notes]

To completely and thoroughly address the aging issues in aircraft wiring required a cultural shift comprising of:

Recognizing importance of electrical wiring in safe operation of airplanes leads to being more proactive; FAA is

- Treating wiring as a system
- Mandating DAH support of the initiative
- Integrating FAA lines of business: joint AFS/AIR activity; and cooperation with & between DAHs and operators

[End speaker notes]

Slide 17: Goal of EPAS Rule

Banner with motto: “Enhance safety by improving all aspects of aircraft electrical wiring”

- Goal is based on –
 - Industry/government committee data-driven recommendations
 - Maximizing harmonization

[Speaker notes]

The goal of EAPAS was to enhance safety by improving all aspects of aircraft electrical wiring

Goal is based on –

- Industry/government committee data-driven recommendations
- Maximizing harmonization with international authorities

So now you hopefully have a better understanding of the history behind the EAPAS rulemaking and how it came into being. We are next going to provide a definition for an EWIS.

[End speaker notes]

Slide 18: EWIS

E - Electrical

W - Wiring

I - Interconnection

S - System

[Speaker notes]

Wiring needs to be treated as an important system on airplanes. Wiring is now referred to as the Electrical Wiring Interconnection System (EWIS).

[End speaker notes]

Slide 19: EWIS Definition

An EWIS is [per new § 25.1701(a)]:

“Any wire, wiring device, or combination of these, including termination devices, installed in any area of the airplane for the purpose of transmitting electrical energy between two or more intended termination points”

Slide 20: ... EWIS is not [§ 25.1701(a)]

- Electrical equipment or avionics qualified to acceptable environmental conditions and testing procedures
- Portable electrical devices not part of airplane's type design
- Fiber optics

Slide 21: Key Point to Remember . . .

Wire and associated components now treated as an airplane system

Slide 22: EWIS Degradation Factors

[Graphic]

In the center, EWIS Degradation surrounded Physical Properties, Age, Installation, Maintenance and Environment pointing into EWIS Degradation.

[End graphic]

[Speaker notes]

EWIS degradation

- EWIS degradation is a process that is a function of several variables; aging is only one of these. **Other main factors** that influence EWIS degradation are the:
 Environment in which it is installed.
 Physical properties of the EWIS.
 Actual physical installation of the EWIS.
 Maintenance (cleaning and repair) of the EWIS.

Characteristics of aging EWIS

- The manner in which EWIS degrades is therefore dependent upon the EWIS type, how it was originally installed, the overall time and environment exposed to in service, and how the EWIS was maintained.
- Service history shows that “how the EWIS is installed” has a direct effect on EWIS degradation. In other words, EWIS that is not selected or installed properly has an increased potential to degrade at an accelerated rate. Therefore, good aircraft EWIS practices are fundamental requirements for EWIS to remain safely intact.

[End speaker notes]

Slide 23: Causes of EWIS Degradation

- Vibration
- Moisture
- Maintenance

[Speaker notes]

Vibration – High vibration areas tend to accelerate degradation over time, resulting in "chattering" contacts and intermittent symptoms. High vibration can also cause tie-wraps, or string-ties to damage insulation. In addition, high vibration will exacerbate any existing problem with wire insulation cracking.

Moisture – High moisture areas generally accelerate corrosion of terminals, pins, sockets, and conductors. It should be noted that EWIS installed in clean, dry areas with moderate temperatures appears to hold up well.

Maintenance – Unscheduled maintenance activities, if done improperly, may contribute to long term problems and EWIS degradation. Repairs that do not meet minimum airworthiness standards may have limited durability. Repairs that conform to manufacturers recommended maintenance practices are generally considered permanent and should not require rework if properly maintained.

- Metal shavings and debris have been discovered on wire bundles after maintenance or repairs have been conducted. Care should be taken to protect wire bundles and connectors during modification work, and to ensure all shavings and debris are cleaned up after work is completed.

- As a general rule, EWIS that is undisturbed will have less degradation than EWIS that is reworked. As EWIS become more brittle with age, this effect becomes more pronounced.

[End speaker notes]

Slide 24: Causes of EWIS Degradation, cont.

- Indirect damage
- Chemical contamination
- Heat
- Installation

[Speaker notes]

Indirect damage – Events such as pneumatic duct ruptures can cause damage that, while not initially evident, can later cause EWIS problems. When such an event has occurred, surrounding EWIS should be carefully inspected to ensure no damage is evident.

Chemical contamination – Chemicals such as hydraulic fluid, battery electrolytes, fuel, corrosion inhibiting compounds, waste system chemicals, cleaning agents, deicing fluids, paint, and soft drinks can contribute to degradation of EWIS. EWIS in the vicinity of these chemicals should be inspected for damage or degradation. Recommended original equipment manufacturer cleaning instructions should be followed.

- Hydraulic fluids, for example, require special consideration. Hydraulic fluid is very damaging to connector grommet and wire bundle clamps, leading to indirect damage, such as arcing and chafing. EWIS components that may have been exposed to hydraulic fluid should be given special attention during EWIS inspections.

Heat – EWIS components exposed to high heat can accelerate degradation, insulation dryness, and cracking. Direct contact with a high heat source can quickly damage insulation. Even low levels of heat can degrade EWIS over long periods of time. This type of degradation is sometimes seen on engines, in galleys, and behind lights.

Installation – EWIS not installed properly can further accelerate the EWIS degradation process. Improper routing, clamping, and terminating during initial installation or during a modifications can lead to EWIS damage.

[End speaker notes]

Slide 25: Current FAA Guidance

[Graphic]

In the center, EWIS Practices, surrounded with Part 25, Part 26, AC 25.1701-1, Policy ANM-01-04, AC 25-10, AC 25-16, AC 43.13-1b and AC 25.27A

[End graphic]

[Speaker notes]

There are direct specific part 25 and part 26 EWIS practices-related to 14 CFR.

There are some specific electrical power wiring requirements, such as §25.1353, but they do not specifically address all aircraft EWIS.

14 CFR 25.1729 requires that instructions for continued airworthiness are developed using analytical procedures, which would include maintenance tasks and intervals for EWIS. A large body of FAA general guidance for wiring practices is in **Chapter 11 of AC 43.13-1b**.

[End speaker notes]

Slide 26: Part 25

- New part 25 requirements for certification of electrical wiring interconnection systems (EWIS)
 - Revised existing EWIS related certification requirements and relocated some of them
 - Created new EWIS certification requirements and placed them in a new subpart H
 - New EWIS ICA requirements

Slide 27: Part 26

- Affects continued airworthiness issues and/or safety improvements for transport airplanes addressed via operational rules
- Supports the ability of operators to comply with the operational rule requirements
- EAPAS Part 26 Requires actions of Design Approval Holders (DAHs), such as:
 - instructions for continued airworthiness,
 - distribution of information to affected operators

Slide 28: Part 26 Model Applicability

- Existing airplanes with a maximum type-certificated passenger capacity of 30 or more, or
- Existing airplanes with a maximum payload capacity of 7,500 pounds or more (reference § 119.3)
- Existing airplane models with a type certificate issued on or after January 1, 1958.

Slide 29: AC 25.1701-1

- This Advisory Circular (AC) provides guidance for certification of electrical wiring interconnection systems (EWIS) on transport category airplanes
 - 14 CFR part 25, subpart H, sections 25.1701 through 25.1733
 - H25.4 and H25.5 of Appendix H to part 25.

Slide 30: AC 25.27A

- Provides guidance for developing maintenance and inspection instructions for EWIS
- Uses an enhanced zonal analysis procedure (EZAP).
- For airplane models whose maintenance programs already include a zonal inspection program, the logic described here provides guidance on improving those programs.

Slide 31: AC 25.27A, cont.

- For airplanes without a zonal inspection program, use of this logic will produce zonal inspections for EWIS that can be added to the existing maintenance program.
- Contains information that can be used by operators to Improve EWIS maintenance practices.
- Stresses the importance of inspecting EWIS and promotes a philosophy of “protect and clean as you go” when performing maintenance, repair, or alterations on an airplane.

Slide 32: Policy ANM-01-04

- Design data should NOT leave the installation to the discretion of the installer.
- Routing of EWIS should follow the criteria established by the FAA in the certification basis, as reflected in the holder’s original or subsequently approved type design.
- Installation drawings / instructions should completely define the required routing and installation with sufficient detail to allow repeatability of the installation.

Slide 33: Guidance: AC 43.13-1b

- AC 43.13-1b: Acceptable Methods, Techniques, and Practices - Aircraft Inspection and Repair
 - Flight Standards AC
 - Chapter 11- Aircraft Electrical Systems

NOTE: The guidance provided in AC 43.13-1b is general in nature and is not to be referenced or used as a substitute for EWIS installation drawings and/or EWIS diagrams.

[Speaker notes]

AC 43.13-1b covers a fairly comprehensive wide range of basic EWIS practices topics.

NOTE: The guidance provided in AC 43.13-1b is general in nature and is not to be referenced or used as a substitute for EWIS installation drawings and/or EWIS diagrams.

[End speaker notes]

Slide 34: Guidance: AC 25-16

- AC 25 -16: Electrical Fault and Fire Prevention and Protection (4/5/91)

- Provides acceptable means to address electrically caused faults, overheating, smoke, and fire in transport category airplanes

[Speaker notes]

AC 25-16 provides wiring practices guidance as it relates to aircraft fire and smoke safety with emphasis on wiring flammability, circuit breaker protection, wiring near flammable fluids, and associated acceptable test methods.

This AC is currently being considered for updating.

[End speaker notes]

Slide 35: Guidance: AC 25-10

- AC 25 -10: Guidance for Installation of Miscellaneous, Non-required Electrical Equipment (3/6/87)
 - Provides acceptable means to comply with applicable 14 CFRs associated with installation of electrical equipment such as galleys and passenger entertainment systems

[Speaker notes]

AC 25-10 mainly covers non-required equipment installations such as galleys, passenger entertainment systems, etc. From a wiring standpoint, all systems should be treated equally, regardless of the functions criticality because of potential fire and smoke hazards.

This AC contains minimal wiring practices specifics, including general load analysis requirements and circuit breaker protection requirements, which are more thoroughly covered in AC 43.13-1b and AC 25-16, so we are not going to be covering 25-10 in any detail.

[End speaker notes]

Slide 36: Electrical Load Determination

- Load analysis
 - Ensure that total electrical load can be safely controlled or managed within rated limits of affected components of aircraft's electrical system (§ 25.1351)
 - New or additional electrical devices should not be installed without an electrical load analysis (AC 43.13-1b)

[Speaker notes]

Electrical load determination is to ensure each aircraft electrical bus can safely support a predetermined amount of electrical load that is based on the electrical capacity of the aircraft generators and the aircraft's overall electrical distribution system.

§25.1351 requirement: It must be determined through analysis that all electrical devices can be safely controlled or managed by the aircraft's electrical system.

AC 43.13-1b: Whenever an electrical device is added, a load analysis should be performed to ensure that the new load on the bus can be powered adequately such that there is adequate electrical power margin to avoid overloading the bus.

Where necessary as determined by a load analysis, wire, wire bundles, and circuit protective devices having the correct ratings should be added or replaced.

[End speaker notes]

Slide 37: Circuit Breaker Devices

Must be sized to open before current rating of attached wire is exceeded, or before cumulative rating of all connected loads is exceeded, whichever is lower (§ 25.1357)

[Speaker notes]

Section 25.1357 requires that automatic protective devices be used to minimize distress to the electrical system and minimize hazard to the airplane in the event of wiring faults or serious malfunction of the system or connected equipment.

[End speaker notes]

Slide 38: Circuit Breaker Protection

- “A circuit breaker must always open before any component downstream can overheat and generate smoke or fire.” (AC 43.13-1b, para. 11-48)
- “Circuit breakers are designed as circuit protection for the wire, not for protection of black boxes or components . . .” (AC 43.13-1b, para. 11-51)

[Speaker notes]

AC 43.13-1b contains some conflicting statements. The bullets in this slide are somewhat contradictory. The **first bullet** says that the breaker must protect against any downstream component failure. The **second bullet** says breakers are designed such that they DO NOT protect components or LRUs.

In reality, **breakers are sized to protect the aircraft wiring as the main design constraint**. Any further protection of components or LRUs is desirable but not mandatory.

Ideally, circuit breakers should protect against any wiring fault that leads to arcing, sparking, flames, or smoke. But as we will learn, thermal circuit breakers do not always detect arcing events.

[End speaker notes]

Slide 39: Circuit Breaker Protection, cont.

- Use of a circuit breaker as a switch is not recommended
 - Repeated opening and closing of contacts can lead to damage and premature failure of circuit breakers

- Most circuit breaker failures are latent

[Speaker notes]

Most circuit breakers, other than some remote control circuit breakers (RCCB), are not designed as switches and should not be used as a switch. Repeated opening and closing of the contacts can lead to damage and premature failure of the circuit breakers. Also keep in mind that circuit breaker failures are, for the most part, latent in nature. So you won't know they have failed until you need them.

[End speaker notes]

Slide 40: Wire Selection

- Size wires so they:
 - Have sufficient mechanical strength
 - Do not exceed allowable voltage drop levels
 - Are protected by circuit protection devices
 - Meet circuit current-carrying requirements

[Speaker notes]

Section 25.1357 requires that automatic protective devices be used to minimize distress to the electrical system and minimize hazard to the airplane in the event of wiring faults or serious malfunction of the system or connected equipment.

[End speaker notes]

Slide 41: Wire Selection, cont.

- Mechanical strength of wire sizes less than #20
 - Do not use wire with less than 19 strands
 - Provide additional support at terminations
 - Should not be used when subject to excessive vibration, repeated bending, or frequent disconnection

(ref. para. 11-66(a), page 11-21)

[Speaker notes]

Wire containing less than 19 conductor strands must not be used.

Consideration should be given to the use of high-strength alloy conductors in small gauge wires to increase mechanical strength.

As a general practice, wires smaller than #20 should be provided with additional clamps and be grouped with at least three other wires.

They also should have additional support at terminations, such as connector grommets, strain relief clamps, shrinkable sleeving, or telescoping bushings.

They should not be used in applications where they will be subjected to excessive vibration, repeated bending, or frequent disconnection from screw termination.
[End speaker notes]

Slide 42: Wire Selection, cont.

- Conductor stranding
 - Minimizes fatigue breakage
- Platings for all copper aircraft wiring
 - Plated because bare copper develops surface oxide film — a poor conductor
 - Tin < 150° C
 - Silver < 200° C
 - Nickel < 260° C

[Speaker notes]

Elevated temperature degradation of tin- and silver-plated copper conductors will occur if they are exposed to continuous operation at elevated levels.

- For **tin-plated conductors**, tin-copper intermetallics will form, resulting in an increase in conductor resistance.
- For **silver-plated conductors**, degradation in the form of interstrand bonding, silver migration, and oxidation of the copper strands will occur with continuous operation near rated temperature, resulting in loss of wire flexibility. Also, due to potential fire hazard, silver-plated conductors shall not be used in areas where they are subject to contamination by ethylene glycol solutions.

Both tin- and silver-plated copper conductors will exhibit degraded solderability after exposure to continuous elevated temperature.

[End speaker notes]

Slide 43: Determining Current-Carrying Capacity

- Effect of heat on wire insulation
 - Maximum operating temperature
 - Single wire or wires in a harness
 - Altitude

[Speaker notes]

Heating is an important factor affecting wire insulation. This must be factored into proper selection of wire for each particular application.

[End speaker notes]

Slide 44: Determining Wire System Design

AC 43.13-1b, Section 5: tables and figures provide an acceptable method of determining wire system design

[Speaker notes]

The applicant should ensure that the maximum ambient temperature that the wire bundles will be subjected to, plus the temperature rise due to the wire current loads, does not exceed the maximum conductor temperature rating.

In smaller harnesses, the allowable percentage of total current may be increased as the harness approaches the single wire configuration.

The continuous current ratings contained in the tables and figures in AC 43.13-1b were derived only for wire application, and cannot be applied directly to associated wire termination devices (e.g., connector contacts, relays, circuit breakers, switches). The current ratings for devices are limited by the design characteristics of the device. Care should be taken to ensure that the continuous current value chosen for a particular system circuit shall not create hot spots within any circuit element which could lead to premature failure.

[End speaker notes]

Slide 45: Wire Substitution for Repairs and Maintenance

- When replacement wire is required, review aircraft maintenance manual to determine if *original aircraft manufacturer* (OAM) has approved any substitution
 - If not approved, then contact OAM for an acceptable replacement

[Speaker notes]

Most aircraft EWIS designs are to specifications that require manufacturers to pass rigorous testing of wires before they are approved or added to a Qualified Products List. Aircraft manufacturers who maintain their own wire specifications exercise close control of their approved sources. Therefore, it is important to review the aircraft maintenance manual or contact the original aircraft manufacturer (OAM) when wire substitutions are necessary.

The OAM may have special concerns regarding shielding, insulation, etc. for certain wiring on the aircraft that perform critical functions or wiring that is chosen based on a set of unique circumstances.

[End speaker notes]

Slide 46: EWIS Routing

- Eliminate potential for chafing against structure or other components
- Position to eliminate/minimize use as handhold or support
- Minimize exposure to damage by maintenance crews or shifting cargo
- Avoid battery electrolytes or other corrosive fluids

[Speaker notes]

In general, EWIS should be routed in such a manner to ensure reliability and to offer protection from the potential hazards shown in this slide.

The next several slides are pictures illustrating these hazards.

[End speaker notes]

Slide 47: EWIS Riding on Structure

Power cables riding on structure can cause damage to the power cables

[Graphic]

First shows Improper wiring with wires touching bottom of area. Second shows Proper wiring with wires not touching bottom of area.

[End Graphic]

[Speaker notes]

Example of wire chafing.

[End speaker notes]

Slide 48: EWIS Riding on Other EWIS

Wire bundles that cross should be secured together to avoid chafing.

[Graphic]

First shows Improper bundle riding over wires. Second show Proper bundle with the bundle securely tied to the other bundle.

[End Graphic]

[Speaker notes]

Example of wire chafing.

[End speaker notes]

Slide 49: EWIS Riding on Lightening Hole Edge

If the grommet is too short, then there is wire bundle chafing

[Graphic]

First shows Improper grommet distance with wires resting on the opening. Second shows Proper grommet distance with wires away from the side of the opening

[End Graphic]

[Speaker notes]

Example of wire chafing.

[End speaker notes]

Slide 50: EWIS as a Handhold

[Graphic]

Shows person's hand holding onto the EWIS with international "not" symbol superimposed across it.

[End Graphic]

[Speaker notes]

Route EWIS so that it is not used as a handhold or as a support for maintenance personnel. In addition, route EWIS so that it avoids:

- Damage by personnel moving within the aircraft.
- Damage by stowage or shifting cargo.
- Damage by battery or acidic fumes or fluids.
- Abrasion in wheel wells where exposed to rocks, ice, mud, etc.
- Damage from external events (zonal analysis/particular risks analysis demands).
- Harsh environments such as severe wind and moisture-prone (SWAMP) areas, high temperatures, or areas susceptible to significant fluid or fume concentration.

EWIS should be routed to permit free movement of shock and vibration mounted equipment, designed to prevent strain on wires, junctions, and supports, and, the EWIS installation should permit shifting of EWIS and equipment necessary to perform maintenance within the aircraft. In addition, wire lengths should be chosen to allow for at least two reterminations.

[End speaker notes]

Slide 51: EWIS Routing, cont.

- Protect EWIS in wheel wells and other exposed areas
- Route EWIS above fluid lines, if practicable
- Use drip loops to control fluids or condensed moisture
- Keep slack to allow maintenance and prevent mechanical strain

[Speaker notes]

Ensure that EWIS components are adequately protected in wheel wells and other areas where they may be exposed to damage from impact of rocks, ice, mud, etc. (If re-routing of EWIS is not practicable, protective jacketing may be installed.) This type of installation must be held to a minimum.

Where practical, route EWIS s and cables above fluid lines. Wires and cables routed within 6 inches of any flammable liquid, fuel, or oxygen line should be closely clamped and rigidly supported. A minimum of 2 inches must be maintained between wiring and such lines or related equipment, except when the wiring is positively clamped to maintain at least 1/2-inch separation or when it must be connected directly to the fluid-carrying equipment.

Ensure that a trap or drip loop is provided to prevent fluids or condensed moisture from running into EWIS and other components. EWIS installed in bilges and other locations where fluids may be trapped are routed as far from the lowest point as possible or otherwise provided with a moisture-proof covering.
[End speaker notes]

Slide 52: EWIS Above Fluid Lines

Broken wire shall not make contact with fluid line

[Graphic]
Shows broken wire exposed end touching the fluid line
[End Graphic]

[Speaker notes]
EWIS above fluid lines. The clamps should be a compression type and should be spaced so that, assuming a wire break, the broken wire will not contact hydraulic lines, oxygen lines, pneumatic lines, or other equipment whose subsequent failure caused by arcing could cause further damage.
[End speaker notes]

Slide 53: Graphic

Wires improperly tied, riding on hydraulic lines, contaminated with caustic fluid

[Graphic]
Shows wires touching hydraulic lines
[End Graphic]

[Speaker notes]
This example shows a number of problems:

- Wires in the bundles are not tied properly.
- The wire bundle is riding hard on the hydraulic lines.
- The wire bundle appears to be contaminated with hydraulic fluid residue.

[End speaker notes]

Slide 54: Y Type Wire Bundle Breakouts

[Graphic]
Bundle showing figure 8 loop as bundle splits into two bundles. Graphic says “**Figure 8 loop may be located before or after tail of Y**” and “**Head of strap shall not be located in this area or touching anything to cause chafing**”
[End graphic]

[Speaker notes]

Wire bundle breakouts. There are three basic wire bundle breakout types used in routing aircraft EWIS. They are called the “Y,” “T,” and Complex types.

The “Y” type of breakout is used when a portion of EWIS from one direction of the wire bundle departs the bundle to be routed in another direction.

- Care should be taken when plastic tie wraps are used to provide wire containment at the breakout so that the tie wrap head does not cause chafing damage to the wire bundle at the breakout junction.

[End speaker notes]

Slide 55: T Type Wire Bundle Breakouts

[Graphic]

Bundle shows a ‘T’ type bundle with a crisscross tie at junction around the “T.” Graphic says “Head of strap shall not be located in this area or touching anything to cause chafing” referring to the top of the bundle and the side of the “T” going up.

[End graphic]

[Speaker notes]

The “T” type of breakout (also called **90° breakout**) is used when portions of EWIS from both directions in the wire bundle depart the bundle to be routed in another direction.

[End speaker notes]

Slide 56: Complex Type Wire Bundle Breakouts

[Graphic]

Shows a terminal block with the wire connections

[End graphic]

[Speaker notes]

A **Complex type** of breakout is generally used to route certain wires out of a wire bundle to a terminal strip, module block, or other termination.

For all types of breakouts, there should be sufficient slack in the wires that are being broken out of the bundle to avoid strain on the wire between the wire bundle and the termination.

[End speaker notes]

Slide 57: Stand-offs

- Use stand-offs to maintain clearance between EWIS and structure
 - Employing tape or tubing is generally *not* acceptable as an alternative
- Exception: Where impossible to install off-angle clamps to maintain EWIS separation in holes, bulkheads, floors, etc.

[Speaker notes]

The EWIS design should preclude wire bundles from contacting structure. Stand-offs should be used to maintain clearance between EWIS and structure.

Employing tape or protective tubing as an alternative to stand-offs **should be avoided** as a primary means of preventing EWIS contact with structure.

Exception: Using tape or tubing is allowed in cases where it is impossible to install off-angle clamps to maintain EWIS separation in holes, bulkheads, floors, etc.

[End speaker notes]

Slide 58: Using Stand-offs

[Graphic]

Graphic shows the Improper method with wires immediately touching the base after using a standoff. Proper method shows wires in standoff not touching base.

[End graphic]

[Speaker notes]

When using standoffs for additional clearance, clamps should not be installed in a manner that defeats the standoff's purpose of providing additional clearance between EWIS and structure.

[End speaker notes]

Slide 59: Bundle riding on structure

[Graphic]

showing bundle touching aircraft structure

[End graphic]

[Speaker notes]

One of the more common aircraft EWIS problems is chafing due to wire bundles coming into contact with aircraft structure or other aircraft equipment.

[End speaker notes]

Slide 60: Graphic

[Graphic]

Wire bundle too close to control cable

[End graphic]

[Speaker notes]

This picture shows a wire bundle that is in close contact with a control cable. Adequate distance between EWIS and control cables should be maintained to account for movement due to slack and maintenance.

[End speaker notes]

Slide 61: Clamping

- Support wires by suitable clamps, grommets, or other devices at intervals of not more than 24 inches
- Supporting devices should be of suitable size and type with wire and/or cables held securely in place without damage to wire or wire insulation

[Speaker notes]

Wire supports and intervals. Clamps and other primary support devices should be constructed of materials that are compatible with their installation and environment, in terms of temperature, fluid resistance, exposure to ultraviolet light, and wire bundle mechanical loads.

- Generally, clamps should not be spaced at intervals exceeding 24 inches. In high vibration areas or areas requiring routing around structural intrusions, the clamping intervals may need to be reduced in order to provide adequate support.

[End speaker notes]

Slide 62: Clamps

- Wire bundles should be snug in clamp (no movement)
 - Cable not able to move axially
- RF cables: do not crush
- Mount clamps with attachment hardware on top
- Tying not used as alternative to clamping

[Speaker notes]

Clamps on wire bundles should not allow the bundle to move through the clamp when a slight axial pull is applied.

Clamps on RF cables must fit without crushing and must be snug enough to prevent the cable from moving freely through the clamp, but may allow the cable to slide through the clamp when a light axial pull is applied. The cable or wire bundle may be wrapped with one or more turns of tape or other material suitable for the environment when required to achieve this fit.

- **Plastic clamps or cable ties** must not be used where their failure could result in interference with movable controls, wire bundle contact with movable equipment, or chafing damage to essential or unprotected EWIS. They must not be used on vertical runs where inadvertent slack migration could result in chafing or other damage.
- Clamps must be **installed with their attachment hardware positioned above them**, wherever practicable, so that they are unlikely to rotate as the result of wire bundle weight or wire bundle chafing.

Clamps lined with nonmetallic material should be used to support the wire bundle along the run. Tying may be used between clamps, but should not be considered as a substitute for adequate clamping. Adhesive tapes are subject to age deterioration and, therefore, are not acceptable as a clamping means.

[End speaker notes]

Slide 63: Example of Correct Cable Slack

[Graphic]

Shows appropriate slack, looks to be about half a wire thickness

[End graphic]

[Speaker notes]

This is an example of an appropriate amount of cable slack between clamps. Appropriate slack protects the wires from stress and from contact with inappropriate surfaces.

- **Too much cable slack** can allow the cable to contact structure or other equipment which could damage the wire bundle.
- **Too little slack** can cause a pre-load condition on the cable which could cause damage to the wire bundle and/or clamps as well.

Also, sufficient slack should be left between the last clamp and the termination or electrical equipment to prevent strain at the terminal and to minimize adverse effects of shock-mounted equipment.

[End speaker notes]

Slide 64: Clamp Distortion

[Graphic]

Shows proper clamp position with no distortion in the rubber clamp. It also shows improper clamp position with distortion of the rubber at the top of one clamp and bottom of another clamp.

[End graphic]

[Speaker notes]

As is shown in the top graphic, the wire bundles are routed perpendicular to the clamp.

- If wire bundles are not routed perpendicular to the clamp (bottom graphic), stress can be created against the clamp and clamp grommet which can distort the clamp and/or clamp grommet. Distorted clamps/clamp grommets can cause wire bundle damage over time.

[End speaker notes]

Slide 65: Clamp Orientation

[Graphic]

Shows proper clamp orientation with the clamp being 90 degrees, plus or minus 5 degrees to the wire. Shows improper clamp orientation with the clamp being greater or less than 90 degrees (plus or minus 5 degrees) to the wire.

[End graphic]

[Speaker notes] This slide further illustrates correct and incorrect clamp orientations. Incorrect clamp orientation can lead to wire bundle damage. [End speaker notes]

Slide 66: Example - Clamp Distortion

[Graphic]

Shows clamp distorted from wire bundle and not being perpendicular to wire.

[End graphic]

[Speaker notes]

This photograph is a good example of clamp distortion. Note that the wire bundle is not perpendicular to the clamp

[End speaker notes]

Slide 67: Plastic Snap-in Clamp (Tie Mount)

[Graphic]

Shows plastic snap-in clamp (tie mount) attached under a support bracket.

[End graphic]

[Speaker notes]

Some EWIS designs utilize plastic snap-in clamps sometimes referred to as “tie mounts.” These types of clamps are not suitable for large wire bundles and should not be used in high temperature or high vibration areas.

- Any type of plastic clamp or cable tie should not be used where their failure could result in interference with movable controls, wire bundle contact with movable equipment, or chafing damage to essential or unprotected EWIS.

[End speaker notes]

Slide 68: Typical Rubber Clamp

[Graphic]

Shows clamp with a rubber cushion, wedge and clamp tab. Also, show bundle of wires in clamp on a standoff. It says that “All wires contained in the rubber cushion” and “no pinching” of the wires.

[End graphic]

[Speaker notes]

A common problem in aircraft EWIS is clamp pinching. This occurs when the clamp is improperly installed or the clamp is too small. Clamps on wire bundles should be selected so that they have a snug fit without pinching wires.

[End speaker notes]

Slide 69: Typical Nylon Closed-Face Clamp Installation

[Graphic]

Shows bundle of wires in clamp on a standoff. It says “do not pinch here” referring to the point where the clamp comes together.

[End graphic]

[Speaker notes]

It is important when adding wiring to an existing wire bundle to evaluate the existing clamp sizing in order to avoid possible clamp pinching. In some cases it may be necessary to increase the size of the clamps to accommodate the new wiring.

[End speaker notes]

Slide 70: Engage Clamp Tab in Slot

[Graphic]

Shows improper where clamp tabs have a separation and proper where clamp tabs are tight and flush to each other

[End graphic]

[Speaker notes]

When using clamp tabs, make sure that the tabs are properly engaged. Otherwise, the tab could become loose and cause subsequent wire damage.

- During EWIS installation inspections, ensure that the clamp is snapped before installing and tightening the bolt.

[End speaker notes]

Slide 71: Clamp Pinching

[Graphic]

Shows improper where the wires are pinched at where the clamp comes together and proper where the wires do not pinch in the clamp.

[End graphic]

[Speaker notes] This slide further illustrates how wires can be pinched and damaged due to improper clamp installation. [End speaker notes]

Slide 72: Clamp Pinching, cont.

[Graphic]

Shows improper where there are two wires in the clamp causing pinching and proper where the right sized clamp is used and not causing any pinching.

[End graphic]

[Speaker notes]

Too much wiring in a clamp or improperly installed clamps can lead to pinching of the wires

[End speaker notes]

Slide 73: Graphic

[Graphic]

Open-faced nylon clamp with cable build-up (missing hardware)

[End graphic]

[Speaker notes]

This picture was taken during a general visual EWIS inspection of a wide-body transport aircraft. Note the missing clamp hardware. Also note that the black cable used a tape build-up at the clamp. Some manufacturer's EWIS specifications allow for wire cable build-up under certain circumstances.

[End speaker notes]

Slide 74: Wire Bend Radii

- Minimum bend radius - 10 times the outside diameter of the largest wire or cable in the group — unsupported
 - *Exceptions*
 - Terminations/reversing direction in bundle (supported at both ends of loop) - 3 times the diameter
 - RF cables - 6 times the diameter
 - Thermocouple wire - 20 times the diameter

[Speaker notes]

The minimum radius of bends in wire groups or bundles must **not be less than 10 times** the outside diameter of the largest wire or cable, except that at the terminal strips where wires break out at terminations or reverse direction in a bundle.

Where the **wire is suitably supported, the radius may be 3 times** the diameter of the wire or cable.

Where it is not practical to install wiring or cables within the radius requirements, the bend should be enclosed in insulating tubing.

The radius for thermocouple wire is 20 times the diameter. (This is very delicate wire.)
Ensure that RF cables, (for example, coaxial and triaxial, are bent at a radius of **no less than 6 times** the outside diameter of the cable.

[End speaker notes]

Slide 75: Minimum Bend Radii

[Graphic]

Wire bundle illustrating

- No support at end of bend
 - Min. bend radius – 10x parameter of wire or cable
- Support at end of bend
 - Min. bend radius 3x diameter of wire
- “T” type bend
 - Min. bend radius 3x diameter of wire

[End graphic]

[Speaker notes]

This illustration shows the proper bend radii for three different scenarios.

[End speaker notes]

Slide 76: Graphic

[Graphic]

Bend radii okay - Greater than 3 times diameter (secured at both ends of loop)

[End graphic]

[Speaker notes]

This photograph shows a wire loop secured at both ends of the loop. In this case, the bend radius should be no less than 3 times the diameter of the largest wire in the wire bundle.

[End speaker notes]

Slide 77: Graphic

[Graphic]

Bend radii problem - Less than 3 times the diameter

[End graphic]

[Speaker notes]

Also supported at each end of the loop, this wire bundle does not meet bend radius standards due to the large wires in the bundle.

[End speaker notes]

Slide 78: Unused Wires

- Secured
 - Tied into a bundle or secured to a permanent structure
- Individually cut with strands even with insulation
- Pre-insulated, closed-end connector or 1-inch piece of insulating tubing folded and tied back

[Speaker notes]

Ensure that unused wires are individually dead-ended, tied into a bundle, and secured to a permanent structure.

- Each wire should have strands cut even with the insulation and a pre-insulated closed end connector or a 1-inch piece of insulating tubing placed over the wire with its end folded back and tied.

[End speaker notes]

Slide 79: Spare Connector Contact: Preparing Single Contact

[Graphic]

Shows wire and contact in tube. The tube is to be 3 times the length of the contact.

[End graphic]

[Speaker notes]

This slide and the next two depict an acceptable method of insulating and physically securing a **spare connector contact** within a wire bundle.

[End speaker notes]

Slide 80: Spare Connector Contact: Folding Tube and Tying Single Contact

[Graphic]

Shows tying tape behind wire and contact meet with .75 inch, plus or minus .15 inch, of tubing to fold

[End graphic]

Slide 81: Spare Connector Contact: Single Contact Attachment to Wire Bundle

[Graphic]

Shows wire, from above, being attached to bundle with one tying tape wrapped around bundle and end of tube on wire and another tying tape wrapped around wire and bundle before tube on wire.

[End graphic]

Slide 82: Spare Wire Termination Using Endcap

[Graphic]

Showing

- Wire and cap in position for cap to slide over wire
- Install end cap over wire end and shrink in place
- Bundle using adhesive and fiberglass tying tape

[End graphic]

[Speaker notes]

Installing prefabricated end caps are an effective method of protecting unused wires with exposed conductors.

- This slide depicts a typical example of the use of a prefabricated end cap.

[End speaker notes]

Slide 83: Unused Wires

[Graphic]

Unused wiring - Improper termination with exposed conductor (should be properly insulated and secured to bundle)

[End graphic]

[Speaker notes]

Found during a general EWIS visual inspection, this example shows two unused wires that have been cut and the conductors are unprotected. In addition, the unused wires are not secured to the wire bundle.

[End speaker notes]

Slide 84: Coil and Stow Methods

Coil and stow short wire bundles in low vibration areas

[Graphic]

wire bundle coiled in a loop with a clamp and wire ties to hold it together

[End graphic]

[Speaker notes]

Coil and stow methods are often used to secure excess length of a wire bundle or to secure wire bundles that are not connected to any equipment, such as wiring provisioning for a future installation.

[End speaker notes]

Slide 85: Coil and Stow Methods, cont.

Coil and stow long wire bundles in low vibration areas

[Graphic]

excess wire looped back and forth to remove the excess. Uses wire ties and clamp to bundle together

[End graphic]

[Speaker notes]

The key objective to coiling and stowing wiring is to safely secure the wire bundle to prevent excessive movement or contact with other equipment that could damage the EWIS.

[End speaker notes]

Slide 86: Coil and Stow Methods, cont.

Coil and stow in medium and high vibration areas

[Graphic]

wire bundle, with a radius between two bundles, tied to a wire bundle at the top and bottom using Teflon tape

[End graphic]

[Speaker notes]

Coil and stow in medium and high vibration areas requires additional tie straps, sleeving, and support.

[End speaker notes]

Slide 87: Stowing Unused Wires

[Graphic]

Improper method with bundle tied to a single wire above it. Proper method with bundle tied and not tied to anything else

[End graphic]

[Speaker notes]

These photos show improper and proper stowing of unused wires.

[End speaker notes]

Slide 88: EWIS Replacement

- EWIS components should be replaced when:
 - Chafed or frayed
 - Insulation suspected of being penetrated
 - Outer insulation is cracking
 - Damaged by or known to have been exposed to electrolyte, oil, hydraulic fluid, etc.

- Evidence of overheating can be seen

[Speaker notes]

EWIS needs to be replaced under a number of circumstances:

- Wiring that has been subjected to chafing or fraying, that has been damaged, or that primary insulation is suspected of being penetrated.
- Wiring on which the outer insulation is brittle when slight flexing causes it to crack.
- Wiring that has weather-cracked outer insulation. NOTE: some wire insulation types appears to be wrinkled when the wire is bent and may not be damaged.
- Wiring that is known to have been exposed to electrolyte or on which the insulation appears to be, or is suspected of being, in an initial stage of deterioration due to the effects of electrolyte.
- There is visible evidence of insulation damage due to overheating.

[End speaker notes]

Slide 89: Heat Discoloration

[Speaker notes]

This photograph shows an example of heat discoloration on protective sleeving which is part of the wire bundle. The large clamp was moved to see the difference in color. In this case, the wiring that is not covered in sleeving shows no signs of heat distress. An adjacent light bulb was radiating enough heat to cause discoloration over time to the protective sleeving.

Although this condition is not ideal, it is acceptable.

[End speaker notes]

Slide 90: Wire Replacement

- Wire should be replaced when:
 - Wire bears evidence of being crushed or kinked
 - Shield on shielded wire if frayed and/or corroded
 - Wire shows evidence of breaks, cracks, dirt, or moisture in plastic sleeving
 - Sections of wire have splices occurring at less than 10-ft intervals

[Speaker notes]

Continuing, these are additional circumstances that warrant replacing EWIS:

- EWIS that bears evidence of having been crushed or severely kinked.
- Shielded EWIS on which the metallic shield is frayed and/or corroded. Cleaning agents (which can cause wire damage) or preservatives should not be used to minimize the effects of corrosion or deterioration of wire shields.

- EWIS showing evidence of breaks, cracks, dirt, or moisture in the plastic sleeves placed over wire splices or terminal lugs.
- Sections of wire in which splices occur at less than 10-foot intervals, unless specifically authorized, due to parallel connections, locations, or inaccessibility.

[End speaker notes]

Slide 91: Wire Replacement, cont.

- Shielding requirements
 - Replacement wires must have the same shielding characteristics as the original wire, such as shield optical coverage and resistance per unit length
 - Replacement wires should not be installed outside the bundle shield

[Speaker notes]

Replacement wires should have the same shielding characteristics as the original wires, such as shield optical coverage and resistance per unit length.

If any wires are going to be replaced inside a shielded wire bundle, the replacement wires should not be installed outside the bundle shield.

For more information on shielding, the *Lightning/HIRF Video and Self-study Guide* is available. (To obtain, see your Directorate training manager.)

[End speaker notes]

Slide 92: Adding or Replacing Wires on a Bundle

[Graphic]

Improper procedure with loose wires not tied down between clamps. Proper procedure with all wires tied to the bundle between clamps.

[End graphic]

[Speaker notes]

When adding or replacing wires on or in a wire bundle, the replacement or added wire should be routed in the same manner as the other wires in the wire bundle.

- Wire bundle clamps and/or ties may need to be loosened or removed in order to properly add or replace wires.
- When the new wire is installed, the ties and clamps should be opened one at a time to avoid excessive disassembly of the wire bundles.

[End speaker notes]

Slide 93: Adding Wires on a Bundle

[Graphic]

First image shows Improperly routed outside of the tie wrap that secures the clamp and the second image show wiring routed correctly

[End graphic]

[Speaker notes]

Proper and improperly routed wires in a bundle

[End speaker notes]

Slide 94: Wire Splicing

- Keep to a minimum
- Avoid in high vibration areas
- Locate to permit inspection
- Stagger in bundles to minimize increase in bundle size
- Use self-insulated splice connector, if possible

[Speaker notes]

Splicing is permitted on EWIS as long as it does not affect the reliability and the electro-mechanical characteristics of the EWIS. Splicing of power wires, co-axial cables, multiplex bus, and large gauge wire should be avoided. If it can't be avoided, then the power wire splicing must have approved data.

- **Splicing of electrical wire should be kept to a minimum** and avoided entirely in locations subject to extreme vibrations. Splicing of individual wires in a group or bundle should have engineering approval and the splice(s) should be located to allow periodic inspection.

Many types of aircraft splice connectors are available for use when splicing individual wires.

- Use of a **self-insulated splice connector** is preferred; however, a non-insulated splice connector may be used provided the splice is covered with plastic sleeving that is secured at both ends.
- **Environmentally-sealed splices** that conform to MIL-T-7928 provide a reliable means of splicing in SWAMP areas. However, a non-insulated splice connector may be used, provided the splice is covered with dual wall shrink sleeving of a suitable material.

[End speaker notes]

Slide 95: Staggered Splices

[Graphic]

Image shows a small section with 4 splices and the wire tie placed so that two splices are on one side and two on the other

[End graphic]

[Speaker notes]

Splices in bundles should be staggered so as to minimize any increase in the size of the bundle that would:

- Prevent bundle from fitting into designated space.
- Cause congestion adversely affecting maintenance.

- Cause stress on the wires.

[End speaker notes]

Slide 96: Graphic

[Graphic]

Overheated wire at the splice

[End graphic]

[Speaker notes]

Splices that are not crimped properly (under or over) can cause increased resistance leading to overheat conditions.

[End speaker notes]

Slide 97: Graphic

[Graphic]

Ganged wire splices

[End graphic]

[Speaker notes]

If splices are not staggered, proper strain relief should be provided in order to avoid stress on the wires. In this particular installation, strain relief was applied to avoid stress on the wires.

[End speaker notes]

Slide 98: Graphic

[Graphic]

Ganged wire splices, 9 splices with 7 splices with slack and 2 splices that are taunt between the clamps.

[End graphic]

[Speaker notes]

The top two wires in this photo are experiencing stress due to a preload condition. Also note that the wire bundle is not properly clamped

[End speaker notes]

Slide 99: Terminals

- Tensile strength of the wire-to-terminal joint should be at least the equivalent tensile strength of the wire
- Resistance of the wire-to-terminal joint should be negligible relative to the normal resistance of the wire

[Speaker notes]

Tensile strength terminals are attached to the ends of electrical wires to facilitate connection of the wires to terminal strips or items of equipment. The tensile strength of the wire-to-terminal joint should be at least equivalent to the tensile strength of the wire itself.

Resistance of wire-to-terminal joint should be negligible, relative to the normal resistance of the wire.

- **Selection of wire terminals.** The following should be considered in the selection of wire terminals.

Current rating.

Wire size (gauge) and insulation diameter.

Conductor material compatibility.

Stud size.

Insulation material compatibility.

Application environment.

Solder/solderless.

[End speaker notes]

Slide 100: Bending of Straight Copper Terminals

[Graphic]

First image shows copper terminal end bent 90 degrees max to the left or right. Second image shows terminal end bent up or down 30 degrees max. Third image shows copper terminal bent up or down 45 degrees max. Fourth image shows a brazed joint with a max 30 degree and the tongue should be even with the end of the terminal.

[End graphic]

[Speaker notes]

If bending of a terminal is necessary, care should be taken to avoid over bending the terminal which can cause damage to the terminal. Also, a terminal can only be bent once since any additional bending can cause damage.

Pre-insulated crimp-type ring-tongue terminals are preferred. The strength, size, and supporting means of studs and binding posts, as well as the wire size, should be considered when determining the number of terminals to be attached to any one post.

In high-temperature applications, the terminal temperature rating must be greater than the ambient temperature plus current related temperature rise. Use of nickel-plated terminals and of uninsulated terminals with high-temperature insulating sleeves should be considered.

Terminal blocks should be provided with adequate electrical clearance or insulation strips between mounting hardware and conductive parts.

Terminals are sensitive to bending at the junction between the terminal ring and the terminal crimp barrel. Bending the terminal more than once or exceeding pre-determined terminal bend limits will usually result in mechanical weakening or damage to the terminal.

This slide is an example of limits established by the OAM with regard to bending the terminal prior to installation.

[End speaker notes]

Slide 101: Terminal Strips

- Barriers to prevent adjacent studs from contacting each other
- Current should be carried by terminal contact surface and not by stud
- Studs anchored against rotation
- Replace defective studs with studs of same size and material, mount securely, tighten terminal securing nut

[Speaker notes]

Wires are usually joined at terminal strips. A terminal strip fitted with barriers should be used to prevent the terminals on adjacent studs from contacting each other.

- Studs should be anchored against rotation. When more than four terminals are to be connected together, a small metal bus should be mounted across two or more adjacent studs. In all cases, the current should be carried by the terminal contact surfaces and not by the stud itself.
- Defective studs should be replaced with studs of the same size and material since terminal strip studs of the smaller sizes may shear due to overtightening the nut. The replacement stud should be securely mounted in the terminal strip and the terminal securing nut should be tight.

[End speaker notes]

Slide 102: Terminal Strips, cont.

Mount strips so loose metallic objects cannot fall across terminal

Provide spare stud for breaks and future expansion

Inspect terminal periodically for loose connections, metallic objects, dirt, and grease accumulation

Can cause arcing, resulting in fire or systems failure

[Speaker notes]

[End speaker notes]

Slide 103: Terminals on circuit breakers

[Graphic]

terminal wires connected to circuit breakers with separate screws

[End graphic]

[Speaker notes]

Connectors and terminals in aircraft require special attention to ensure a safe and satisfactory installation. Every possibility of terminals not being torqued properly, due to misinstallation, poor maintenance, and service life, should be addressed in the design.

- Electrical equipment malfunction has frequently been traced to poor terminal connections at terminal boards.
- Loose contact surfaces can produce localized heating that may ignite nearby combustible materials or overheat adjacent wire insulation.

Note the green torque stripes painted on the terminal fasteners in this picture. This is an excellent method to quickly determine if a terminal fastener is still torqued to its original value.

[End speaker notes]

Slide 104: Graphic

[Graphic]

Power feeder terminals

[End graphic]

[Speaker notes]

Again, you can see the red colored torque stripes applied to these high current power feeder terminations. High current terminals are more sensitive to increased resistance due to a improperly torqued terminal.

- As a side note, the power feeder cables should not be touching each other without being suitably tied with spacers or other securing device.

[End speaker notes]

Slide 105: Terminal Lugs

- Connect wiring to terminal block studs
- No more than 4 lugs, or 3 lugs and a bus bar, per stud
- Lug hole size should match stud diameter
 - Greatest diameter on bottom, smallest on top
 - Tightening terminal connections should not deform lugs

[Speaker notes]

Wire terminal lugs should be used to connect wiring to terminal block studs or equipment terminal studs. No more than four terminal lugs or three terminal lugs and a bus should be connected to any one stud.

- Total number of terminal lugs per stud includes a common bus bar joining adjacent studs. Four terminal lugs plus a common bus bar thus are not permitted on one stud.

Terminal lugs should be selected with a stud hole diameter that matches the diameter of the stud. However, when the terminal lugs attached to a stud vary in diameter, the greatest diameter should be placed on the bottom and the smallest diameter on top.

Tightening terminal connections should not deform the terminal lugs or the studs. Terminal lugs should be so positioned that bending of the terminal lug is not required to remove the fastening screw or nut, and movement of the terminal lugs will tend to tighten the connection.

[End speaker notes]

Slide 106: Terminal Lugs, cont.

- Aluminum lugs
 - Crimped to aluminum wire only
 - Special attention needed to guard against excessive voltage drop at terminal junction
 - Inadequate terminal contact area
 - Stacking errors
 - Improper torquing
 - Use calibrated crimp tools

[Speaker notes]

Aluminum terminal lugs should be crimped to aluminum wire only.

The tongue of the aluminum terminal lugs or the total number of tongues of aluminum terminal lugs when stacked, should be sandwiched between two flat washers (cadmium plated) when terminated on terminal studs. Spacers or washers should not be used between the tongues of like material terminal lugs.

Special attention should be given to aluminum wire and cable installations to guard against conditions that would result in excessive voltage drop and high resistance at junctions that may ultimately lead to failure of the junction.

- Examples of such conditions are improper installation of terminals and washers, improper torsion (“torquing” of nuts), and inadequate terminal contact areas.

Note that aluminum wire is normally used in sizes of 10 gauge and larger to carry electrical power in large transport category aircraft in order to save weight. Although not as good a conductor as copper, aluminum is lighter when compared to copper and the weight savings can be significant for a large aircraft that may have several hundred feet of power feeder cable.

Because aluminum is used primarily for high current power applications, the terminal junctions are more sensitive to conditions leading to increased junction resistance which can cause arcing and localized heat distress.

[End speaker notes]

Slide 107: Terminal Stacking (like materials)

[Graphic]

Explode diagram of Terminal stacking. From bottom to top: terminal stud, copper terminal lugs, flat washer, lock washer and nut.

[End graphic]

[Speaker notes]

Terminal stacking materials and methods

- Multiple wires often terminate onto a single terminal stud. Care should be taken to install the terminal properly. The materials that the terminals are constructed of will impact the type of stacking methods used. **Dissimilar metals, when in contact, can produce electrolysis** that can cause corrosion, thus degrading the terminal junction resistance and causing arcing or hot spots.
- For stacking **terminals that are made of like materials**, the terminals can be stacked directly on top of each other.

[End speaker notes]

Slide 108: Terminal Stacking (unlike materials)

[Graphic]

Explode diagram of Terminal stacking. From bottom to top: terminal stud, flat washer, aluminum terminal, flat washer, copper terminal, flat washer, aluminum terminal, flat washer, lock washer and nut

[End graphic]

[Speaker notes]

When **stacking unlike materials together** (for example, aluminum and copper), a cadmium-plated flat washer is usually needed to isolate the dissimilar metals.

[End speaker notes]

Slide 109: Terminal Stacking Methods

[Graphic]

Explode diagram of "one-sided entry with two terminals.". From bottom to top: terminal stud, crimp barrel (belly down), crimp barrel (belly up), flat washer, lock washer and nut

[End graphic]

[Speaker notes]

When **two terminals are installed on one side** of the terminal strip, care should be taken to ensure that the terminal crimp barrels do not interfere with one another. One method to avoid this problem is to install the terminals with the barrels "back to back."

[End speaker notes]

Slide 110: Terminal Stacking Methods, cont.

[Graphic]

Explode diagram of "one-sided entry with 3 terminals." From bottom to top: terminal stud, crimp barrel (belly down) in "V" split, crimp barrel (belly down) in "V" split, crimp barrel (belly up)) in center of "V" split, flat washer, lock washer and nut

[End graphic]

[Speaker notes]

This illustration depicts a terminal installation with **three terminals entering on one side.**

[End speaker notes]

Slide 111: Terminal Stacking Methods, cont.

[Graphic]

Explode diagram of "one-sided entry with 4 terminals".. From bottom to top: terminal stud, crimp barrel (belly down) in "V" split, crimp barrel (belly down) in "V" split, crimp barrel (belly up)) in center of "V" split, crimp barrel (belly up)) in center of "V" split, flat washer, lock washer and nut

[End graphic]

[Speaker notes]

This illustration depicts a terminal installation with **four terminals entering on one side.**

The stacking method used to connect terminals to terminal strips should cause no interference between terminals that could compromise the integrity of the terminal junction.

[End speaker notes]

Slide 112: Terminal Tightening Hardware

[Graphic]

Improper tightening: terminal stud, flat washer, terminals, flat washer, lock washer not compressed, space, and nut. Proper tightening: terminal stud, flat washer, terminals, flat washer, lock washer compressed, and nut.

[End graphic]

[Speaker notes]

Service history has shown that hardware stack up at terminals is prone to human error.

Omission of lock washers, incorrect washers, improper sizing of washers, etc. has been a definite problem.

It is important to use the correct tightening hardware and install it correctly for a given installation. This illustration shows a typical flat washer/lock washer/nut installation. It is important to ensure the locking washer is fully compressed and is adjacent to the nut. After the terminal is completely assembled, there should be a **minimum of two to three threads showing on the stud when the nut is properly torqued.**

[End speaker notes]

Slide 113: Washer Size Selection

[Graphic]

Improper size shows washer raised on portion of terminal. Proper size shows washers without any raised portions on terminal and all the washers are the same size.

[End graphic]

[Speaker notes]

It is important to select and use the correct size washers in any termination. Undersized or oversized washers can lead to increased junction resistance and localized heat or arcing. This illustration shows how an improperly sized washer can lead to insufficient contact between the terminal and terminal lug.

[End speaker notes]

Slide 114: Lock Washers

[Speaker notes]

In this photograph, the lock washer is missing from the terminal on the left.

[End speaker notes]

Slide 115: Grounding: Definition

Grounding is the process of electrically connecting conductive objects to either a conductive structure or some other conductive return path for the purpose of safely completing either a normal or fault circuit.

[Speaker notes]

Grounding. One of the more important factors in the design and maintenance of aircraft electrical systems is proper bonding and grounding. Inadequate bonding or grounding can lead to unreliable operation of systems, such as EMI, electrostatic discharge damage to sensitive electronics, personnel shock hazard, or damage from lightning strike.

[End speaker notes]

Slide 116: Grounding

- Types of grounding
 - AC returns
 - DC returns
 - Others
- Avoid mixing return currents from various sources
 - Noise will be coupled from one source to another and can be a major problem for digital systems

[Speaker notes]

Grounding types: AC returns, DC returns, and others.

Mixing return currents. If wires carrying return currents from different types of sources, such as signals or DC and AC generators, are connected to the same ground point or have a common connection in the return paths, an interaction of the currents will occur. This interaction may not be a problem, or it could be a major non-repeatable anomaly.

- To minimize the interaction between various return currents, different types of grounds should be identified and used. As a minimum, the design should use three ground types: (1) AC returns, (2) DC returns, and (3) all others.
- For distributed power systems, the power return point for an alternative power source would be separated.

For example, in a two-AC generator system (one on the right side and the other on the left side), if the right AC generator were supplying backup power to equipment located in the left side, (left equipment rack) the backup AC ground return should be labeled "AC Right." The return currents for the left generator should be connected to a ground point labeled "AC Left."

[End speaker notes]

Slide 117: Grounding, cont.

- Design of ground path should be given as much attention as other leads in the system
- Grounding should provide a constant impedance
- Ground equipment items externally even when internally grounded
 - Avoid direct connections to magnesium structure for ground return

[Speaker notes]

Design of ground paths. The design of the ground return circuit should be given as much attention as the other leads of a circuit.

Constant impedance. A requirement for proper ground connections is that they maintain an impedance that is essentially constant.

- Ground return circuits should have a current rating and voltage drop adequate for satisfactory operation of the connected electrical and electronic equipment.

- EMI problems, that can be caused by a system's power wire, can be reduced substantially by locating the associated ground return near the origin of the power wiring (e.g., circuit breaker panel) and routing the power wire and its ground return in a twisted pair.
- Special care should be exercised to ensure replacement on ground return leads. The use of numbered insulated wire leads instead of bare grounding jumpers may aid in this respect.

External grounding of equipment items. In general, equipment items should have an external ground connection, even when internally grounded. Direct connections to a magnesium structure (which may create a fire hazard) must **not** be used for ground return.

[End speaker notes]

Slide 118: Grounding, cont.

- Heavy current grounds
 - Attach to individual grounding brackets attached to aircraft structure with a proper metal-to-metal bond
 - Accommodate normal and fault currents of system without creating excessive voltage drop or damage to structure
 - Give special attention to composite aircraft

[Speaker notes]

Heavy current grounds. Power ground connections for generators, transformer rectifiers, batteries, external power receptacles, and other heavy-current loads must be attached to individual grounding brackets that are attached to aircraft structure with a proper metal-to-metal bonding attachment.

- This attachment and the surrounding structure must provide adequate conductivity to accommodate normal and fault currents of the system without creating excessive voltage drop or damage to the structure.
- At least three fasteners, located in a triangular or rectangular pattern, must be used to secure such brackets in order to minimize susceptibility to loosening under vibration.
- If the structure is fabricated of a material such as carbon fiber composite (CFC), which has a higher resistivity than aluminum or copper, it will be necessary to provide an alternative ground path(s) for power return current.

[End speaker notes]

Slide 119: Bonding

- Equipment bonding
 - Low impedance paths to aircraft structure required for electronic equipment to provide radio frequency return circuits
 - Facilitates reduction in EMI for most electrical equipment

- Cases of components that produce EMI should be grounded to structure

[Speaker notes]

Equipment bonding. Low impedance paths to aircraft structure are normally required for electronic equipment to provide radio frequency return circuits and for most electrical equipment to facilitate reduction in EMI. The cases of components that produce electromagnetic energy should be grounded to structure.

- To ensure proper operation of electronic equipment, it is particularly important to conform the system's installation specification when inter-connections, bonding, and grounding are being accomplished.

[End speaker notes]

Slide 120: Bonding, cont.

- Metallic surface bonding
 - Electrically connecting conductive exterior airframe components through mechanical joints, conductive hinges, or bond straps
 - Protects against static charges and lightning strikes

[Speaker notes]

Metallic surface bonding. All conducting objects on the exterior of the airframe must be electrically connected to the airframe through mechanical joints, conductive hinges, or bond straps capable of conducting static charges and lightning strikes.

- Exceptions may be necessary for some objects such as antenna elements, whose function requires them to be electrically isolated from the airframe. Such items should be provided with an alternative means to conduct static charges and/or lightning currents, as appropriate.

[End speaker notes]

Slide 121: Bonding, cont.

- Static bonds
 - Required for all isolated conducting parts with area greater than 3 in² and a linear dimension over 3" subjected to appreciable electrostatic charging due to precipitation, fluid, or air in motion
 - Resistance of less than 1 ohm when clean and dry usually ensures static dissipation on larger objects

[Speaker notes]

Static bonds. All isolated conducting parts inside and outside the aircraft, having an area greater than 3 in² and a linear dimension over 3 inches, that are subjected to appreciable electrostatic charging due to precipitation, fluid, or air in motion, should have a mechanically secure electrical connection to the aircraft structure of sufficient conductivity to dissipate possible static charges.

- A resistance of less than 1 ohm when clean and dry will generally ensure such dissipation on larger objects. Higher resistances are permissible in connecting smaller objects to airframe structure.

[End speaker notes]

Slide 122: EWIS Identification

- Necessary for:
 - Safety of operation
 - Safety to maintenance personnel
 - Ease of maintenance
- To identify performance capability, use wire material part number and five digit/letter code identifying manufacturer

[Speaker notes]

Purpose. The proper identification of EWIS components with their circuits and voltages is necessary to provide safety of operation, safety to maintenance personnel, and ease of maintenance.

Common manufacturer marking process. Each wire and cable should be marked with a part number. It is common practice for wire manufacturers to follow the wire material part number with the five digit/letter **C.A.G.E.** code identifying the wire manufacturer. Using this code, existing installed wire that needs replacement can be identified as to its performance capabilities. This helps to prevent the inadvertent use of lower performance and unsuitable replacement wire.

- **NOTE:** Special care should be taken when hot stamping wire. Service history has shown problems associated with hot stamping due to insulation damage caused during the process.
- **The method of identification** should not impair the characteristics of the EWIS.
- **Original wire identification.** To facilitate installation and maintenance, retain the original wire-marking identification. The wire identification marks should consist of a combination of letters and numbers that identify the wire, the circuit it belongs to, its gauge size, and any other information to relate the wire to a EWIS diagram. All markings should be legible in size, type, and color.
- **Identification and information related to the EWIS diagrams.** The wire identification marking should consist of similar information to relate the wire to a EWIS diagram.

[End speaker notes]

Slide 123: EWIS Identification, cont.

- Wire identification marks identify wire, circuit, and gauge size
- Markings should be legible in size, type, and color at 15-inch maximum intervals along the wire (directly on wire or indirect [sleeve/tag])

- Less than 3 inches needs no marking
 - Readable without removing clamps, ties, or supporting devices

[Speaker notes]

Marking EWIS in aircraft. Identification markings generally are placed at each end of the wire and at 15-inch maximum intervals along the length of the wire.

- Wires less than 3 inches long need not be identified.
- Wires 3 to 7 inches in length should be identified approximately at the center.
- Added identification marker sleeves should be located so that ties, clamps, or supporting devices need not be re-moved in order to read the identification.
- The wire identification code must be printed to read horizontally (from left to right) or vertically (from top to bottom). The two methods of marking wire or cable are as follows:
 - (1) **Direct marking** is accomplished by printing the cable's outer covering.
 - (2) **Indirect marking** is accomplished by printing a heat-shrinkable sleeve and installing the printed sleeve on the wire or cables outer covering. Indirect-marked wire or cable should be identified with printed sleeves at each end and at intervals not longer than 6 feet. The individual wires inside a cable should be identified within 3 inches of their termination.
- The marking should be permanent such that environmental stresses during operation and maintenance do not adversely affect legibility.

[End speaker notes]

Slide 124: Marking a Wire Bundle

[Graphic]

First image shows bundle with no marking and the second image shows bundle marked with identification number on a tag.

[End graphic]

[Speaker notes]

There can be serious repercussions when there is a situation in which a number of unmarked cables are disconnected. When the cables reconnected, the chances are high that they will be connected incorrectly, thus causing numerous problems.

[End speaker notes]

Slide 125: Connectors

- Many types, however crimped contacts generally used

- Circular type
- Rectangular
- Module blocks
- Selected to provide maximum degree of safety and reliability given electrical and environmental requirements
 - Use environmentally-sealed connectors to prevent moisture penetration

[Speaker notes]

Connectors. The number and complexity of EWIS have resulted in an increased use of electrical connectors. The proper choice and application of connectors is a significant part of the aircraft EWIS system. Connectors should be kept to a minimum, selected, and installed to provide the maximum degree of safety and reliability to the aircraft. For the installation of any particular connector assembly, the specification of the manufacturer should be followed.

Purpose and types. The connector used for each application should be selected only after a careful determination of the electrical and environmental requirements. Consider the size, weight, tooling, logistic, maintenance support, and compatibility with standardization programs.

- For ease of assembly and maintenance, connectors using crimped contacts are generally chosen for all applications except those requiring a hermetic seal.
- A replacement connector of the same basic type and design as the connector it replaces should be used.
- With a crimp type connector for any electrical connection, the proper insertion, or extraction tool should be used to install or remove wires from such a connector. Refer to manufacturer or aircraft instruction manual.
- After the connector is disconnected, inspect it for loose soldered connections to prevent unintentional grounding.
- Connectors that are susceptible to corrosion difficulties may be treated with a chemically inert waterproof jelly or an environmentally-sealed connector may be used.
- **NOTE:** Although not required by AC 43.13-1b, moisture-proof connectors should be used in all areas of the aircraft, including the cabin. Service history indicates that most connector failures occur due to some form of moisture penetration. Even in the pressurized, environmentally-controlled areas of the cockpit and cabin, moisture can occur due to “rain in the plane” type of condensation that generally is a problem in all modern transport category aircraft.

[End speaker notes]

Slide 126: Circular Connectors

[graphic]

Three images showing 6 different types of circular connectors

[End graphic]

[Speaker notes]

Although AC 43.13-1b does not address pin layout design aspects, consideration should be given to the design of the pin arrangement to avoid situations where pin-to-pin shorts could result in multiple loss of functions and/or power supplies. For example, you would avoid 115 Vac, 400Hz being located adjacent to low power wires, such as 28 and 5 Vdc.

A wide variety of circular environment-resistant connectors are used in applications where they will probably be subjected to fluids, vibration, thermal, mechanical shock, corrosive elements, etc. In addition, firewall class connectors incorporating these same features should be able to prevent the penetration of the fire through the aircraft firewall connector opening and continue to function without failure for a specified period of time when exposed to fire. Hermetic connectors provide a pressure seal for maintaining pressurized areas.

- When EMI/RFI protection is required, special attention should be given to the termination of individual and overall shields. Backshell adapters designed for shield termination, connectors with conductive finishes, and EMI grounding fingers are available for this purpose.

[End speaker notes]

Slide 127: Circular Connectors, cont.

[graphic]

Images shows 3 different locking devices

[End graphic]

[Speaker notes]

In medium or high vibration areas it may be necessary to provide a locking device to keep the connectors from loosening.

[End speaker notes]

Slide 128: Improper Lock Wire Installation

[Speaker notes]

This slide shows a lock wire improperly installed. The lock wire is installed on the "loosening" side of the connector; it should be on the "lightening" side.

[End speaker notes]

Slide 129: Proper Lock Wire Installation

[Speaker notes]

This is an example of a properly installed lock wire on the “lightening” side.
[End speaker notes]

Slide 130: Rectangular Connectors

[graphic]

Image shows four types of rectangular connectors

[End graphic]

[Speaker notes]

Rectangular connectors are typically used in applications where a very large number of circuits are accommodated in a single mated pair. They are available with a great variety of contacts, which can include a mix of standard, coaxial, and large power types. Coupling is accomplished by various means.

- Smaller types are secured with screws that hold their flange together.
- Larger ones have integral guide pins that ensure correct alignment, or jackscrews that both align and lock the connectors.

Rack and panel connectors use integral or rack-mounted pins for alignment and box mounting hardware for couplings.

[End speaker notes]

Slide 131: Module Blocks (Terminal Blocks)

[Graphic]

Shows two types of modular blocks

[End graphic]

[Speaker notes]

Module blocks accept crimped contacts similar to those on connectors. Some use internal busing to provide a variety of circuit arrangements.

- Module blocks (or terminal blocks) are useful where a number of wires are connected for power or signal distribution. When used as grounding modules, they save and reduce hardware installation on the aircraft.
- Standardized modules are available with wire-end grommet seals for environmental applications and are track-mounted.

[End speaker notes]

Slide 132: Terminal Block Grommet Distortion

[Speaker notes]

For complex wire breakouts that are terminated into terminal blocks, care must be taken to allow enough slack to prevent excessive forces from pulling the terminated wires that are inserted into the terminal block.

- This condition can lead to terminal block grommet distortion, which can lead to wire damage or a wire that will be pulled free from the terminal block.

[End speaker notes]

Slide 133: Grommet Distortion

[Graphic]

First image shows Improper: grommet distortion due to tight wires; not enough slack. Second image shows Proper: no excessive tension on wires; enough slack to avoid grommet distortion

[End graphic]

Slide 134: Conduits

- Purpose
 - Mechanical protection of wires and cables
 - Grouping and routing wires
- Standards
 - Absence of abrasion at end fittings
 - Proper clamping
 - Adequate drain holes free of obstructions
 - Minimized damage from moving objects
 - Proper bend radii

[Speaker notes]

Purpose. Primarily the purpose of conduits is for mechanical protection of cables or wires. Secondly, conduits are used for environmental protection and grouping of wires by signal type.

Standards

- **Conduit should be inspected for:** proper end fittings; absence of abrasion at the end fittings; proper clamping; distortion; adequate drain holes that are free of dirt, grease, or other obstructions; and freedom from abrasion or damage due to moving objects, such as aircraft control cables or shifting cargo.
- **Size of conduit.** Conduit size should be selected for a specific wire bundle application to allow for ease in maintenance, and possible future circuit expansion, by specifying the conduit inner diameter (I.D.) about 25 percent larger than the maximum diameter of the wire bundle.

Conduit fittings. Wire is vulnerable to abrasion at conduit ends. Suitable fittings should be affixed to conduit ends in such a manner that a smooth surface comes in contact with the wire. When fittings are not used, the end of the conduit should be flared to prevent wire insulation damage. Conduit should be supported by use of clamps along the conduit run.

[End speaker notes]

Slide 135: Conduit Installation Guidelines

- Do not locate conduit where service or maintenance personnel might use as handhold or footstep
- Provide inspectable drain holes at the lowest point in conduit run — remove drilling burrs carefully
- Support conduit to prevent chafing against structure and avoid stressing end fittings

[Speaker notes]

Conduit installation. Conduit problems can be avoided by following these guidelines:

- Do not locate conduit where service or maintenance personnel might use it as a handhold or footstep.
- Provide inspectable drain holes at the lowest point in a conduit run. Drilling burrs should be carefully removed.
- Support conduit to prevent chafing against structure and to avoid stressing its end fittings.

[End speaker notes]

Slide 136: Conduit Covering

[Graphic]

First image shows damaged conduit covering. Second image shows an acceptable conduit covering with no damage

[End graphic]

[Speaker notes]

F O D is a big problem with damaged conduit covering.

[End speaker notes]

Slide 137: Wire Insulation Selection

- Chose characteristics based on environment
 - Abrasion resistance
 - Arc resistance
 - Corrosion resistance
 - Cut-through strength
 - Dielectric strength
 - Flame resistant
 - Mechanical strength

- Smoke emission
- Fluid resistance
- Heat distortion

[Speaker notes]

Environmental characteristics. As shown in this slide, there are many insulation materials and combinations used in aircraft wiring. Wire insulation characteristic should be chosen based on meeting FAA flame resistance and smoke emission requirements (25.869) and the environment in which the wire is to be installed.

[End speaker notes]

Slide 138: Flame Resistant Insulating Materials

Polymer	Mil Spec
PTFE	22759/12
ETFE	22759/16
Aromatic polyamide	81381
Composite	22759/80-92

[Speaker notes]

These are the four most common types of insulation materials used in aircraft today. All of the wire insulating materials in this slide meet the minimum FAA smoke and flammability standards.

[End speaker notes]

Slide 139: Selecting Insulating Materials

FACT: There is no “perfect” insulation system for aerospace wire and cable

The designer’s task:

- Consider trade-offs to secure best balance of properties
- Consider influence of design, installation and maintenance

.....for each application!

Slide 140: How to Choose Wire Insulation

- Seek the best balance of properties:
 - Electrical
 - Mechanical
 - Chemical
 - Thermal

Plus

- Nonflammability and low smoke

Slide 141: Comparative Properties of Wire Insulation Systems

Ranking 1 is most desirable and 4 is the least desirable

Relative Ranking	1	2	3	4
Weight	PIE	TFE	COMP	PTFE
Temperature	PTFE	COMP	PI	ETFE
Abrasion resistance	PI	ETFE	COMP	PTFE
Cut-through resistance	PI	COMP	ETFE	PTFE
Chemical resistance	PTFE	ETFE	COMP	PI
Flammability	PTFE	COMP	PI	ETFE
Smoke generation	PI	COMP	PTFE	ETFE
Flexibility	PTFE	ETFE	COMP	PI
Creep (at temperature)	PI	COMP	PTFE	ETFE
Arc propagation resistance	PTFE	ETFE	COMP	PI

[Speaker notes]

PI [Aromatic Polyimide (KAPTON)] - (mil spec 81381)

- *Desirable properties:* abrasion/cut-through, low-smoke/non-flame, weight/space
- *Limitations:* arc-track resistance, flexibility

ETFE (TEFZEL) - (mil spec 22759/16)

- *Desirable properties:* chemical resistance, abrasion resistance, ease of use
- *Limitations:* high temperature, cut-through, thermal rating (150°C)

Composite (TKT) - (mil spec 22759/80-92)

- *Desirable properties:* high temperature rating (260°C), cut-through resistance, arc-track resistance
- *Limitations:* outer layer scuffing

PTFE (TEFLON) - (mil spec 22759/12)

- *Desirable properties:* 260°C thermal rating, low-smoke/non-flame, high flexibility

Limitations: Cut-through resistance, “creep” at temperature

[End speaker notes]

Slide 142: Conclusion on Insulation

- Aircraft designer can choose among many polymeric materials
- Physical and chemical properties are equally important
- Safest system combines “balance of properties” with inherent flame and/or smoke resistance

Slide 143: AC 25-16: Electrical Fault and Fire Detection

- Supplements existing guidance provided in AC 43.13-1b
- Should apply to new airplanes, as well as modifications
- Not intended to take the place of instructions or precautions provided by aircraft/equipment manufacturers

[Speaker notes]

The purpose of AC 25-16, “Electrical Fault And Fire Prevention,” is to provide information on electrically caused faults, overheat, smoke, and fire in transport category airplanes. Acceptable means are provided to minimize the potential for these conditions to occur, and to minimize or contain their effects when they do occur. An applicant may elect to use any other means found to be acceptable by the FAA.

This AC is currently being reviewed and will be revised based on recent service history and ATSRAC recommendations.

[End speaker notes]

Slide 144: AC 25-16: Circuit Protection Devices (CPDs)

- Circuit breaker resets
 - Can significantly worsen an arcing event
 - Crew should only attempt to reset a tripped breaker if function is absolutely required
 - Information should be provided in AFMs or AFM revisions or supplements

[Speaker notes]

Information should be provided in FAA-approved Airplane Flight Manuals (AFM) or AFM revisions or supplements that the crew should only attempt to restore an automatically-disconnected power source or reset or replace an automatically-disconnected circuit protection device (CPD) that affects flight operations or safety.

- **NOTE:** It is strongly recommended that circuit breakers for non-essential systems **not** be reset in flight.

Most transport OAMs and operators are revising their procedures to **not** allow circuit breaker resets in flight following a circuit breaker trip event. Service history has shown that resetting a circuit breaker can greatly influence the degree of arcing damage to the EWIS. Each successive attempt to restore an automatically-disconnected CPD, can result in progressively worsening effects from arcing.

[End speaker notes]

Slide 145: Arc Tracking and Insulation Flashover

(Caused by multiple circuit breaker resets)

[Graphic]

shows wiring burned and broken from arcing

[End graphic]

[Speaker notes]

This picture shows the effects of multiple circuit breaker resets. In this case, the original arcing event was not able to be determined due to the severe secondary damage following the circuit breaker resets.

[End speaker notes]

Slide 146: EWIS Separation

- Regulatory requirements
 - Sections 25.1707, 25.1709, 25.903(d), 25.631
- Manufacturers' standards
 - Power/signal wire separation
 - EMI concerns

[Speaker notes]

EWIS separation/segregation is a fundamental design technique used to isolate failure effects such that certain single failures that can compromise redundancy are minimized. EWIS separation is also used to control the effects of EMI in aircraft EWIS.

- From a regulatory standpoint, we have regulations in place that may influence EWIS design with respect to separation/segregation.
- In addition, manufacturers may have company design standards which establish EWIS separation requirements with respect to power and signal routing which are usually driven from a EMI standpoint.

The next few slides briefly present the primary regulations associated with EWIS separation/segregation.

[End speaker notes]

Slide 147: System Separation: EWIS § 25.1707

- Applies to each EWIS on airplane

- Requires adequate physical separation between EWIS and certain airplane systems known to have potential for creating a hazardous condition, for example:
 - Fuel systems
 - Hydraulic systems
 - Oxygen systems
 - Water/waste systems

Slide 148: System Separation: EWIS § 25.1707, cont.

- Adequate physical separation must be achieved by separation distance or by a barrier that provides protection equivalent to that separation distance
- “Hazardous” -- must perform a qualitative design assessment of installed EWIS
 - Use engineering & manufacturing judgment
 - Evaluate relevant service history to decide whether an EWIS, any other type of system, or any structural component could fail so that a condition affecting the airplane’s ability to continue safe operation could result

Slide 149: System Safety: EWIS § 25.1709

- EWIS be designed and installed so each
 - catastrophic failure condition is extremely improbable, and does not result from a single failure, and
 - each hazardous failure condition is extremely remote
- Both functional and physical failures of EWIS must be assessed when demonstrating compliance with this rule to fully assess effect of EWIS failures

Slide 150: EWIS Separation from a 25.903(d) Standpoint

- Turbine engine installations: Minimize hazards in case of rotor failure
 - Project debris path through aircraft
 - Determine vulnerable areas where redundancy can be violated
 - May need to separate certain critical systems components including EWIS, e.g., electrical power feeders, fly-by-wire control paths

[Speaker notes]

Recently, the JAA requirements with respect to uncontained engine failure assessment were harmonized with the FAA and were issued as AC 20-128A. AC 20-128A provides specific methods for demonstrating compliance with 25.903(d).

- The primary requirement relative to uncontained engine failure is to use practical design precautions to minimize the risk of catastrophic damage due to non-contained engine rotor debris.

An element of difficulty is introduced when the fuselage diameter is exposed to the relatively large diameter fan rotors of modern high-bypass-ratio turbofan engines.

Separation of critical systems EWIS may be a primary factor in establishing compliance.

[End speaker notes]

Slide 151: EWIS Separation from a 25.631 Standpoint

- Continued safe flight and landing after impact with 8-lb. bird
 - Consider protected location of control system elements
 - If impact can effect redundant system EWIS, may need additional physical protection of EWIS or wiring separation
 - E.g.: Impact brow area above windshield could affect electrical power redundancy in some aircraft

[Speaker notes]

The birdstrike impact areas of the aircraft should be assessed for their structural strength by test and/or approved analysis methods. Any penetrations or deformations of the aircraft structure should be further analyzed for the effect of systems installation.

- For example, if a birdstrike test on the cockpit overhead eyebrow area indicates an elastic deformation of 2 inches, then the deformation should be analyzed or superimposed on whatever systems may be installed in the overhead cockpit area at that particular deformation location. In many aircraft, electrical and/or hydraulic control panels and associated EWIS are installed in the overhead cockpit area (this is a relatively small area).
- The effect of the birdstrike can be analyzed with respect to a common cause failure standpoint. EWIS separation aspects of the design may be an element in compliance to this rule.

[End speaker notes]

Slide 152: Post-TC EWIS Separation

- Maintain EWIS separation requirements throughout life of aircraft
 - STC applicants may not be aware of separation or other EWIS requirements (i.e., do not have needed design data)
 - EWIS added or moved as part of the STC should satisfy original separation requirements and EWIS standards
 - FAA policy letter ANM-01-04

[Speaker notes]

A potential problem with STCs and other modifications to transport aircraft is that the applicants may not analyze their proposed EWIS installation with respect to the OAM's EWIS

separation requirements and other OAM EWIS design standards. Added or modified EWIS could possibly defeat the OAM EWIS philosophy and create unsafe conditions. The FAA is currently in the process of drafting policy. The draft policy letter will clarify FAA's policy to require that type design data packages for multiple approvals include the following:

- A drawing package that completely defines the configuration, material, and production processes necessary to produce each part in accordance with the certification basis of the product.
- Any specifications referenced by the required drawings.

Drawings that completely define the location, installation, and routing, as appropriate, of all equipment in accordance with the certification basis of the product.

- Examples of such equipment are wire bundles, plumbing, control cables, and other system interconnecting hardware.
- If the modification being approved is a change to a type certificated product, the modification must be equivalent to and compatible with the original type design standards.

Instructions for Continued Airworthiness (ICA) prepared in accordance with the requirements of 21.50 ("Instructions for continued airworthiness and manufacturer's maintenance manuals having airworthiness limitations sections").

[End speaker notes]

Slide 153: Instructions for Continued Airworthiness (ICAs)

EWIS ICAs are developed using Enhanced Zonal Analysis Procedure (EZAP):

- Each zone of airplane
- Each zone with EWIS
- Each EWIS zone with combustible materials
- Each EWIS zone close to both primary and back-up flight controls and lines
- Tasks, intervals, and procedures to reduce combustibles (i.e. clean-as-you-go)
- Instructions for protections & caution information

[Speaker notes]

14 CFR 25.1729 requires applicants to submit Instructions for Continued Airworthiness, otherwise known as the maintenance requirements, for the proposed EWIS installation as part of the compliance data package. Historically, EWIS has been thought of as "fit and forget" and typically has not been properly addressed in the ICA data package submitted to the FAA for approval.

In light of ATSRAC recommendations, the FAA requires applicants to submit EWIS-related maintenance requirements to the FAA ACO and AEG offices for approval to satisfy the intent of 25.1729. This slide shows some of the issues that need to be addressed for wire replacements instructions.

[End speaker notes]

Slide 154: Why EZAP?

- EZAP used to develop ICA to prevent the possibility of smoke and fire by
 - Minimizing accumulation of combustibles on and around EWIS
 - Detecting EWIS degradations
- This leads to fewer EWIS and other airplane systems failures and to safer operation

Slide 155: 3 EWIS Inspection Types

- General Visual Inspection (GVI)
- Stand-Alone GVI
- Detailed Inspection (DET)

Slide 156: General Visual Inspection (GVI)

- A visual examination of an interior or exterior area, installation, or assembly to detect obvious damage, failure, or irregularity. This level of inspection is made from within touching distance unless otherwise specified.

[Speaker notes]

For General Visual Inspection, a mirror may be necessary to enhance visual access to all exposed surfaces in the inspection area. This level of inspection is made under normally available lighting conditions such as daylight, hangar lighting, flashlight, or droplight and may require removal or opening of access panels or doors. Stands, ladders, or platforms may be required to gain proximity to the area being checked.

[End speaker notes]

Slide 157: Stand-Alone GVI

- A general visual inspection that is not performed as part of a zonal inspection. Even in cases where the interval coincides with the zonal inspection, the stand-alone GVI remains an independent step on the work card.

Slide 158: Detailed Inspection (DET)

- An intensive examination of a specific item, installation, or assembly to detect damage, failure, or irregularity. DET is discussed in greater detail in section 14b(1) of AC 25.27A.

Slide 159: EWIS Inspection Focus Areas

- Clamping points
 - Improper installation
 - Clamp/wire damage
 - Clamp cushion migration
- Connectors
 - Worn seals
 - Loose connectors
 - Lack of strain relief
 - Drip loops
 - Tight wire bends

[Speaker notes]

Clamping points - Wire chafing is aggravated by loose clamps, damaged clamps, clamp cushion migration, or improper clamp installations.

Connectors - Worn environmental seals, loose connectors, excessive corrosion, missing seal plugs, missing dummy contacts, or lack of strain relief on connector grommets can compromise connector integrity and allow contamination to enter the connector, leading to corrosion or grommet degradation. Drip loops should be maintained when connectors are below the level of the harness and tight bends at connectors should be avoided or corrected.

[End speaker notes]

Slide 160: EWIS Inspection Focus Areas, cont.

- Terminations
 - Lugs/splices
- Backshells
 - Improper build-up
 - Lack of strain relief
- Damaged sleeving and conduits
- Grounding points
 - Tightness
 - Cleanliness
 - Corrosion

[Speaker notes]

Terminations - Terminal lugs and splices are susceptible to mechanical damage, corrosion, heat damage and chemical contamination. Also, the build up and nut torque on large-gauge wire studs is critical to their performance.

Backshells - Wires may break at backshells, due to excessive flexing, lack of strain relief, or improper build-up. Loss of backshell bonding may also occur due to these and other factors.

Damaged sleeving and conduits - Damage to sleeving and conduits, if not corrected, will often lead to wire damage.

Grounding points - Grounding points should be checked for security (i.e. tightness), condition of the termination, cleanliness, and corrosion. Any grounding points that are corroded or have lost their protective coating should be repaired.

[End speaker notes]

Slide 161: EWIS Inspection Locations: Examples

- Wings
 - Exposed EWIS on leading/trailing edges during flap/slat operation
- Engine/APUs/pylon/nacelle
 - Heat/vibration/chemical contamination
 - High maintenance area
- Landing gear/wheel wells
 - Environmental/vibration/chemical

[Speaker notes]

EWIS inspection locations. Available data indicate that the locations shown on the slide should receive special attention in an operator's EWIS inspection program.

Wings - The wing leading and trailing edges are areas that experience difficult environments for EWIS installations. The wing leading and trailing edge EWIS is exposed on some aircraft models whenever the flaps or slats are extended. Other potential damage sources include slat torque shafts and bleed air ducts.

Engine, pylon, and nacelle area - These areas experience high vibration, heat, frequent maintenance, and are susceptible to chemical contamination.

APU - Like the engine/nacelle area, the APU is susceptible to high vibration, heat, frequent maintenance, and chemical contamination.

Landing gear and wheel wells - This area is exposed to severe external environmental conditions in addition to vibration and chemical contamination.

[End speaker notes]

Slide 162: EWIS Inspection Locations, cont.

- Electrical panels/line replacement units (LRU)
 - High density areas
 - High maintenance activity
 - Prone to broken/damaged EWIS
- Batteries
 - Chemical contamination/corrosion
- Power feeders
 - Feeder terminations
 - Signs of heat distress

[Speaker notes]

Electrical panels and line replaceable units (LRUs) - Panel EWIS is particularly prone to broken wires and damaged insulation when these high density areas are disturbed during troubleshooting activities, major modifications, and refurbishment. One repair facility has found that wire damage was minimized by tying EWIS to wooden dowels. This reduced wire disturbance during modification. It is also recommended to remove entire disconnect brackets, when possible, instead of removing individual receptacles.

Batteries - Wires and EWIS hardware in the vicinity of all aircraft batteries should be inspected for corrosion and discoloration. Discolored wires should be inspected for serviceability. Corroded wires and/or EWIS hardware should be replaced.

Power feeders - Operators may find it advantageous to inspect splices and terminations for signs of overheating and security. If any signs of overheating are seen, the splice or termination should be replaced. This applies to galley power feeders, in addition to the main and APU generator power feeders. The desirability of periodically retorquing power feeder terminations should be evaluated.

[End speaker notes]

Slide 163: EWIS Inspection Locations, cont.

- Under galleys and lavatories
 - Susceptible to fluid contamination
 - Fluid drainage provisions
- Cargo bay/underfloor area
 - High maintenance activity
- Surfaces, controls, doors
 - Moving and bending wire harnesses
- Near access panels
 - Prone to accidental damage

[Speaker notes]

Under galleys and lavatories - Areas under the galleys, lavatories and other liquid containers are particularly susceptible to contamination from coffee, food, water, soft drinks and lavatory fluids, etc. Fluid drain provisions should be periodically inspected and repaired as necessary.

Cargo bay/under floor - Cargo can damage EWIS. Damage to EWIS in the cargo bay under floor can occur due to maintenance activities in the area.

Surfaces, controls, and doors - Moving or bending harnesses should be inspected at these locations.

Access panels - Harnesses near access panels may receive accidental damage and should have special emphasis inspections.

[End speaker notes]

Slide 164: 25.1703 Requirements for preemptive maintenance

- New rule assures EWIS components selection carried out safely, consistently, & standardized
- What does it require?
 - a. EWIS Components must function properly when installed
 - b. EWIS components must be qualified for airborne use
 - i. Household wire or wire used on consumer electronics not acceptable unless shown to meet all part 25 certification requirements
 - c. Expected service life must be addressed
 - i. Limitations must be part of the ICA (H25.4)
 - d. Must consider known characteristics in relation to each specific application
 - i. Includes wire's insulation susceptibility to arc tracking

Slide 165: Use of Grommets

[Graphic]

First image shows improper grommet use by leaving a space. Second image shows proper grommet use by leaving no space

[End graphic]

[Speaker notes]

The grommet should cover the entire edge and come together at the top of the hole.

[End speaker notes]

Slide 166: Potential Foreign Object Damage

[Graphic]

First image shows metallic shavings on wires. Second image shows washers and scrap wires in area.

[End graphic]

[Speaker notes]

These photographs show foreign object damage (FOD) that can cause damage to EWIS components. Metallic shaving pose a serious threat which can damage wire insulation and cause subsequent arcing and fire damage. This is one of the reasons for the clean-as-you-go maintenance philosophy.

[End speaker notes]

Slide 167: Tie Wrap Ends

[Speaker notes]

It is important to cut the tie wrap ends after securing the wires in order to avoid possible interference with other EWIS components.

[End speaker notes]

Slide 168: Clamp Cushion

[Speaker notes]

Damaged clamp cushions can cause EWIS damage that can lead to arcing.

[End speaker notes]

Slide 169: Sleeving Installation

[Graphic]

First image shows sleeving not completely around wire bundle. Second image shows sleeving overlapping wire bundle.

[End graphic]

[Speaker notes]

Protective sleeving should overlap at least 30% to ensure 100% coverage of the wire bundle.

[End speaker notes]

Slide 170: Part 25 and 26 Required Compliance Documentation

- Project Specific Certification Plan (PSCP) (EWIS/EZAP aspects)
 - Load analysis
 - EWIS Installation Drawings and EWIS Diagrams (25.1701, including identification of EWIS components per 25.1711)
 - EWIS separation requirements (25.1707)
 - Systems Safety Analysis (25.1709)
 - ICA for EWIS including any airworthiness limitations (25.1729 and 25.1703, respectively)

Slide 171: EWIS Diagrams

- Wire selection
 - Gauge/breaker size
 - Insulation
 - EWIS Identification
 - Environmental considerations
- Connectors
 - Pin/socket ratings
 - Pin arrangement (best practices)

- Environmental considerations
- Grounding

[Speaker notes]

The engineer or designee should review the EWIS diagrams and verify the following points. This information should be available on the EWIS diagrams or referenced to the source.

Wire selection - The wires must be sized properly and the circuit breaker sized to adequately protect the wire considering the ambient temperature of the environment. The circuit breaker protecting the wire should open before the circuit breaker protecting the upstream bus.

- The wire insulation and conductor plating must be suitable for the environment plus any further temperature rise due to dissipated power.

Connectors - Ensure that the connectors are suitable for the environment and the pins and sockets are properly rated to handle the power demands of the circuit.

- As we discussed earlier, pin arrangements should minimize the possibility of shorts between power, ground, and/or signals. Verify that separation requirements from the safety assessment process are addressed. Also, ensure unused pins are properly protected.

Grounding - Ensure circuits have proper grounding.

[End speaker notes]

Slide 172: EWIS Installation Drawings

- Clamps
 - Proper size, type, and material
 - Spaced appropriately for environment
 - Mounted correctly
- Feed throughs/pass throughs
 - Grommets used when necessary
 - Wire bundles properly supported

[Speaker notes]

It is important to note that installation drawings generally do not provide the necessary detail to ensure proper clamping, routing, and termination of EWIS for a given installation.

It is advisable for the engineer or designee to perform a first-of-a-model or first-of-a-design general EWIS compliance inspection in addition to reviewing the EWIS diagrams and EWIS installation drawings. Consideration should be given to the complexity of the EWIS in determining the appropriate depth of the compliance inspection.

The engineer or designee should ensure that adequate installation drawings exist and review the drawings and perform the compliance inspection to verify the items noted on the following slides (which we discussed in detail earlier).

Clamps must be suitable with respect to size, type, and material. Also ensure that an adequate number of clamps are used to properly support the wire bundle. Clamps should be mounted correctly with proper orientation.

Feed throughs/pass throughs - Grommets suitable for the environment must be used when the wire bundle passes through pressure bulkhead, firewall, and other openings in the structure.
[End speaker notes]

Slide 173: EWIS Installation Drawings, cont.

- Routing
 - Chafing
 - Location with respect to fluid lines, lavs, and galleys
 - EWIS Identification (component marking)
 - Drip loops
 - Bend radius
 - Coil, cap, and stow methods
 - Human factors (hand/step holds)
 - Protected against cargo/maintenance

[Speaker notes]

EWIS routing should be reviewed to ensure proper clearance from aircraft structure, fluid lines, and other equipment.

- Consideration should be given to the effects on EWIS from maintenance, shifting cargo, and passengers. Proper bend radius, use of drip loops, and proper coil and stow methods should be verified. EWIS that could be used as hand or step holds should be minimized or placarded.

[End speaker notes]

Slide 174: EWIS Installation Drawings, cont.

- Routing, cont.
 - Accessible for maintenance, repairs, and inspection
 - Proper slack
 - Segregation and separation
 - Compatible with OAM standards
 - Does not violate any regulatory safety requirements

[Speaker notes]

Connectors, clamps, splices, and terminations should be accessible for maintenance, repairs, and inspection. Ensure that the EWIS is secure yet not preloaded and that enough slack exists to account for shock-mounted equipment, maintenance, and breakouts to terminals, as appropriate.

For EWIS modifications to existing aircraft, the routing should be compatible with safety requirements and the OAM EWIS philosophy with respect to existing separation and segregation standards.

[End speaker notes]

Slide 175: EWIS Installation Drawings, cont.

- Conduits
 - Sized properly
 - Appropriate for environment
 - Conduit ends are terminated
 - Bend radius
 - Drain holes
 - Metallic - Are EWIS components properly protected inside?
 - Aircraft EWIS Practices

[Speaker notes]

Conduits. Ensure that conduits are sized properly and appropriate for the environment.

- Pay particular attention to the conduit end points to ensure proper termination.
- Conduit bend radii should be suitable for both the conduit and wire bundle inside the conduit.
- Ensure that low spots in the conduit have drain holes that can be maintained and inspected.
- Also, ensure that EWIS in metallic conduit is protected in a suitable manner.

[End speaker notes]

Slide 176: Points of Contact:

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